

Date: Thursday, 20/11/2008 3:37:09 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 43650	
<b>Estimate Number</b> : 11181	
<b>P.O. Number</b> :	<b>Part Number</b> : D32941
<b>This Issue</b> : 20/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3294 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42029	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 21/12/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.01</u>	
<b>Comment</b> : Est A 04.08.24 New issue KJ/JLM	
Est Rev:B Now On Waterjet 07-03-26 JLM	
Est Rev:C 08-07-16 Redesign part DD verified by:EC	
Est Rev:D 08-10-06 revB as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S080	2024-T3 .080 sheet
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MKT NOT PULLED



**Comment:** Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
 (M2024T3S.080)  
 Identify for D3294-1  
 Batch: 110347 B8-12-22

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3294  
 Dwg Rev: B B8-12-22  
 Prog Rev: B  
 \*\*\*\*\*grain direction on a 45 deg as per dwg\*\*\*\*\*  
 2-Deburr if necessary B8-12-22



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B8-12-22**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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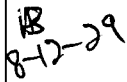
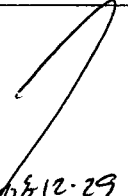

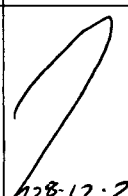


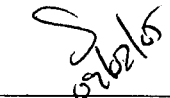


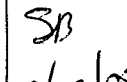

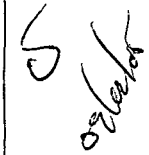


08.12.25 (11)

**Comment:** SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: 3394-1 PAR #: N/A Fault Category: Rel/Prod Assy mat NCR: Yes No DQA: D Date: 09/02/11  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: HP Date: 09/02/11

NCR: <u>113650</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-29	2-0	1 part scrap. holes in part (center cut out) was shifted 0.080" upwards, and only 4 holes are good. outside dims are good. R.C. Machine not function Sheet moved, process.		Scrap - destroy no replace.	 08-12-29			
09/02/05	5	1 Part is at .860 should be at .910 <sup>+</sup> .030	 09.02.05 Q51042	THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT THE DISTANCE BTW THE EDGE AND THE OUTSIDE OF BEVD (.0.860") IS GREATER THAN THE DISTANCE BETWEEN THE INSIDE EDGE AND OUTSIDE OF BOLT PRESCRIBED ON THE ENTIRE LENGTH OF THE BOTTOM OF THE PART (0.71").	 09/02/05	 09/02/05	 09/02/05	 09/02/05
		RL Human error			 09/02/05	 09/02/05		 09/02/05

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:37:09 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43650

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC

NC BRAKE



(P10)  
Previous Page

Comment: NC BRAKE

1- deburr

2- Form as per Dwg D3294

So 09/02/05 (17)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorter 05 (11)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(11)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/05

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:40  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:10

MD / FL 09/02/06

(11)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-02-06

(11)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N using white fine point permanent ink marker, then Stock

Location: 211

9/2/06

(11)

SLP

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/06

Job Completion



09-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

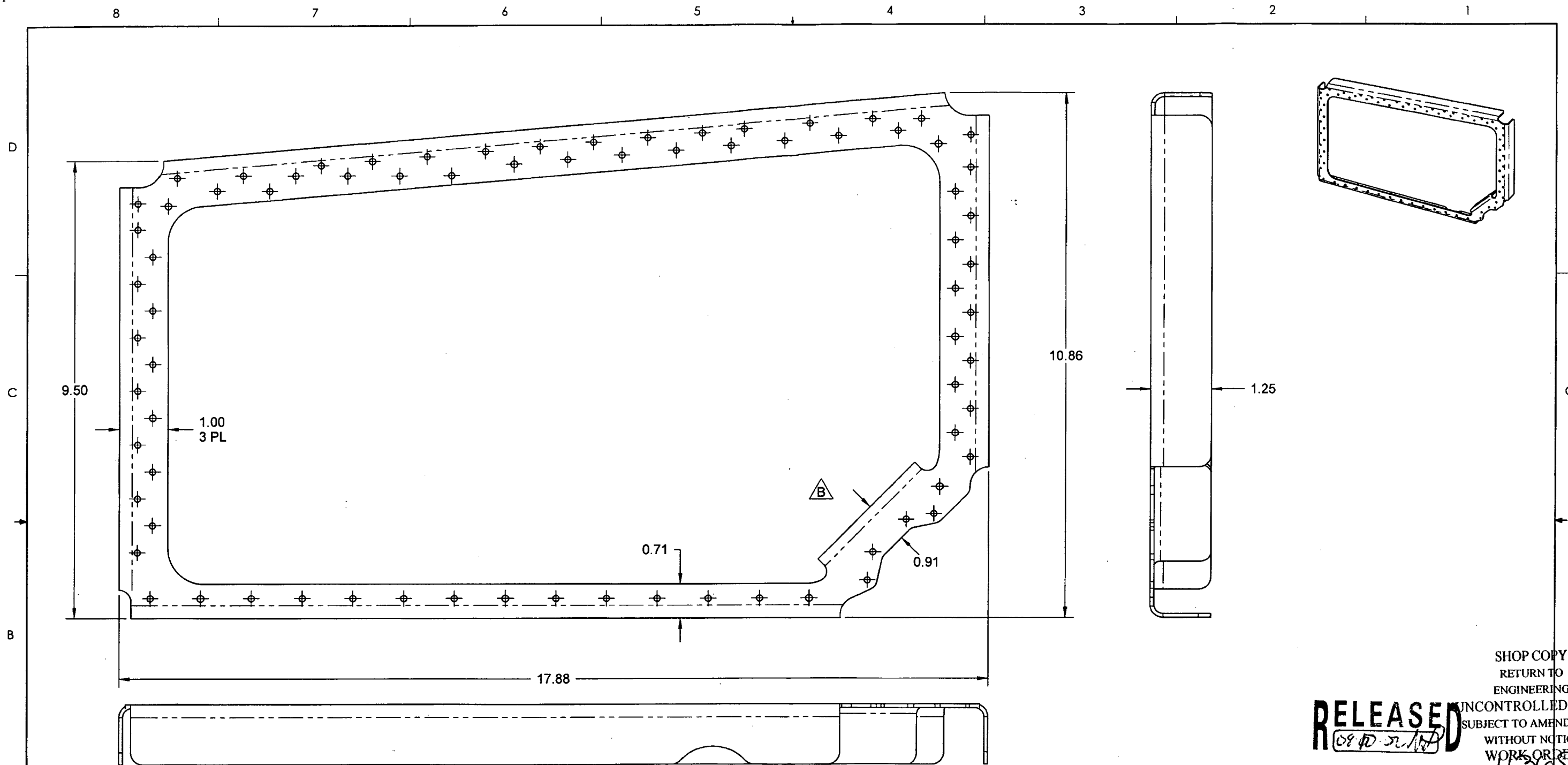
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





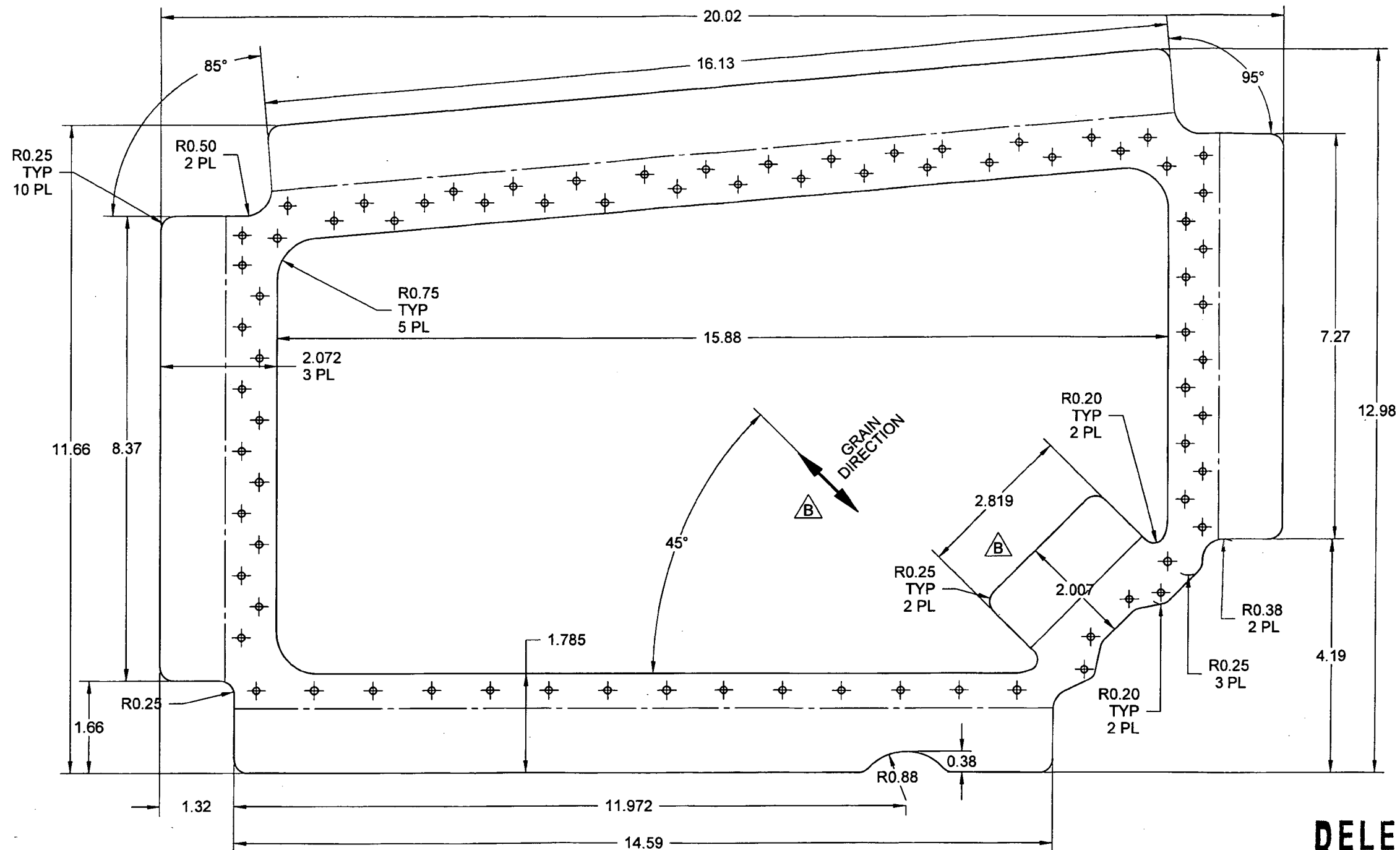
**D3294-1 BRACKET**  
(MADE FROM D3294-1F)

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3294-1 USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.79 lbs
- 8) MACHINE PER DRAWING FILE "D3294-B2.DXF"

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WITHOUT NOTICE  
WORK ORDER  
NO. 43680







B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	08.09.22
A	NEW ISSUE	04.06.28
REV.	DESCRIPTION	BY DATE
DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO. D3294	REV. B
MFG. APPR.		SHEET 1 OF 3
APPROVED	TITLE BRACKET	SCALE NTS
DE APPR.		
DATE	08.09.22	
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**D3294-1F BRACKET FLAT PATTERN**

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WORK ORDER  
NO. 43650

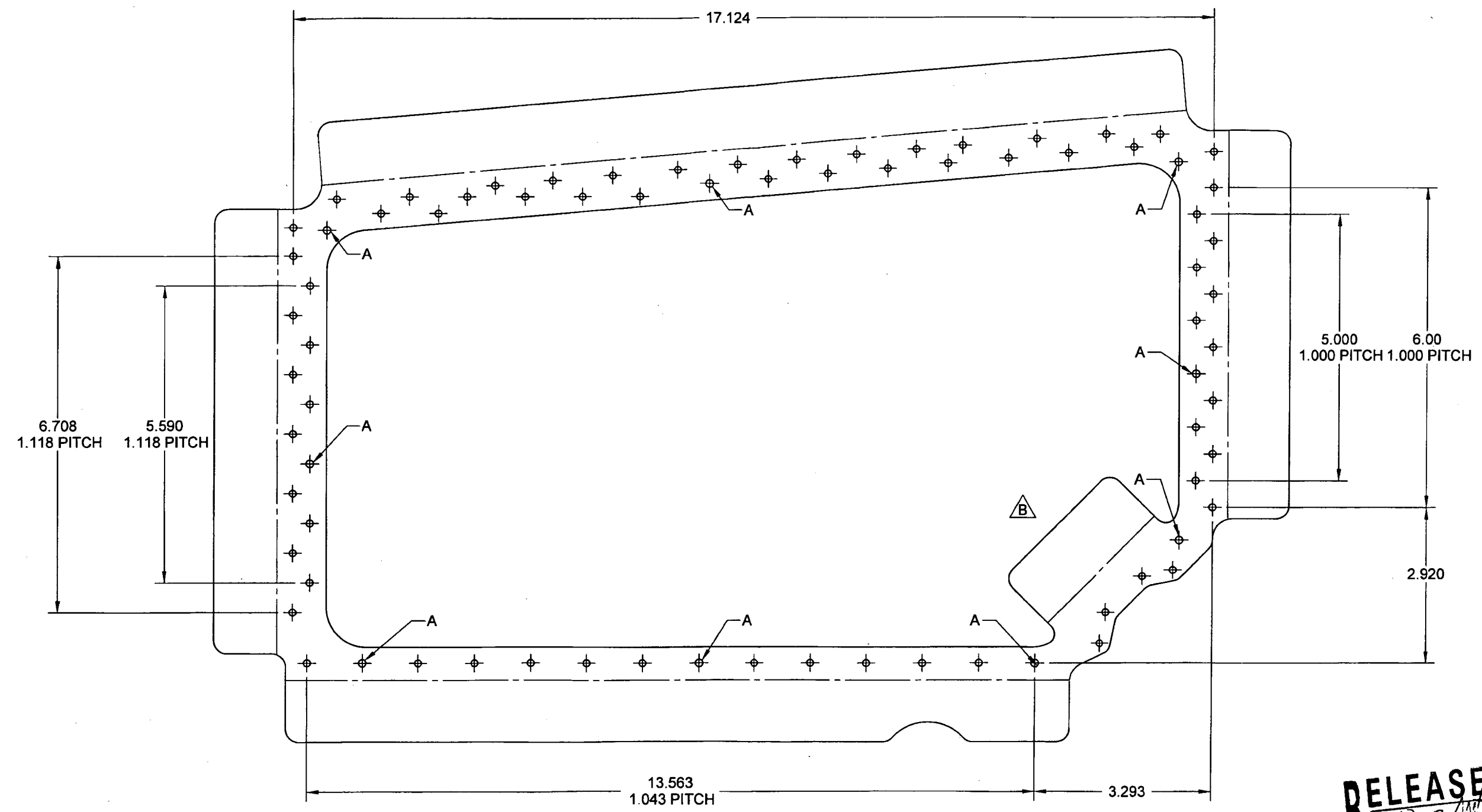
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18-10-52/MT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3294	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



LABEL	HOLE $\phi$
ALL HOLES UNLESS NOTED	0.128
A	0.141

**D3294-1F BRACKET FLAT PATTERN**  
SUPPLEMENTAL

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3294</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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08-10-22

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